



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBT400224
Job Sheet 169859



Part No: RBT400224

Job Qty: 2 ea

Part Name: Clevis Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/2/18

Job Tracking No:

Due Date: 1/30/18

Created By: Diane Baker

Type: Stock

Description:

Customer: Bell Helicopter Miami Inc (CEDWA04)

PO Box 3689 Bristol, TN, 37625 USA ph:(954) 491-5071

Note: DWG REV 3 IPP REV:A 17.07.17 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	2 pcs		1/30/18	0.00	0.00	Purchasing		AC 18/03/21
110	Packaging	2 pcs		1/30/18	0.00	0.00	Packaging2		AC 18/03/21
120	QC	2 pcs		1/30/18	0.00	0.00	QC6		38
130	Packaging	2 pcs		1/30/18	0.00	0.00	Packaging3-1		MAR 23, 2018
140	QC21-SA	2 Ea		1/30/18	0.00	0.00	QC21		MAR 18/03/26

Part Op 100 - ISSUE P/O: P0039711 SUPPLIER: METEC MANUFACTURE RBT400224 AS PER DWG C OF C
Descriptions: IS REQUIRED

21
9-80

MAR 27 2018

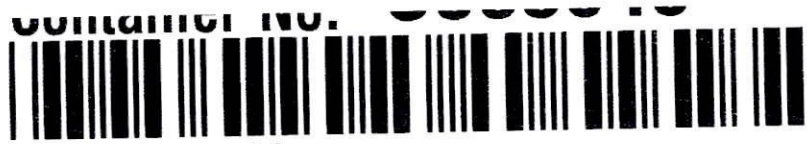
Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
100-Purchasing	RBT400224P	2	1	0	0

5053633

Part Specifications

Specifications could not be found.



Clevis Assembly

PART NO: RBT400224

Serial No/Batch: S053640

Revision:

Operation: Packaging

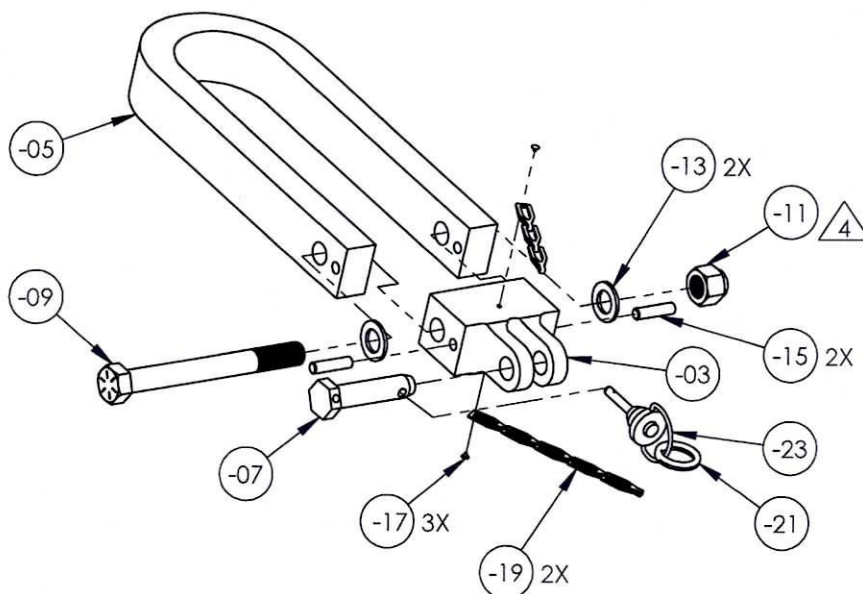
Change No:

Mfg Date: 03/21/18

Job No: 169859

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-05 CORRECTED PROOF LOAD TESTING FROM 40000 LBS. TO 25000 lbs. AND CAPACITY TO 10000 lbs. PER INFORMATION FROM STAN.	7/20/2010	WP	RW
2		-07 CHD FROM AN8-31 A BACK TO NAS1308-38. -09 CHD FROM AN8-46A TO NAS1308-64.	8/16/2010	WP	RW
3	15-0203	DELETED NOTE 3, ADDED NOTE 4.	8/13/2015	RJC	JAG



4 Wks

~~Part 1507-05~~

Metec -1760 com (bbs) x2

NOTE:

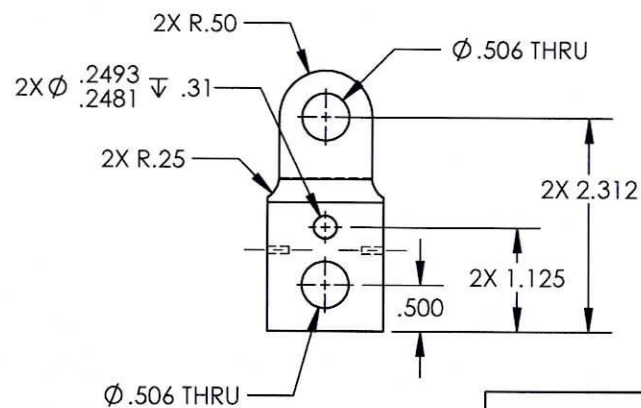
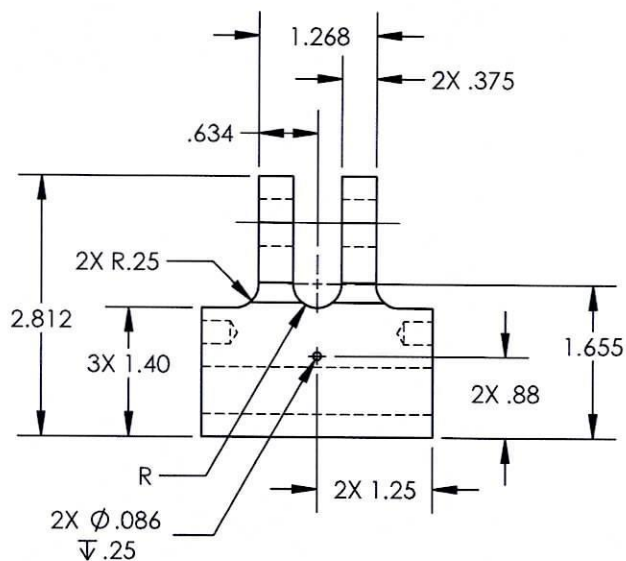
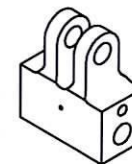
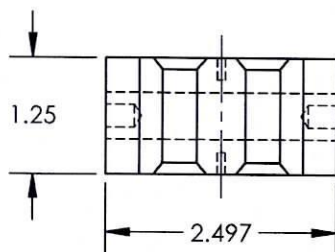
1. ORIGINAL T/N 204-011-178-001.
2. PROOF LOAD TEST ASSEMBLY TO 25,000 lbs, WORK CAPACITY IS 10,000 lbs.
4. TORQUE -11 NUT TO 440-550 in. lbs.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-03	1	CLEVIS	4140/4142		2
			-05	1	BELL	4140/4142		3
			-07	1	BOLT PIN	STEEL	NAS1308-38 MODIFIED	4
		B/O	-09	1	BOLT	STEEL	NAS1308-64	
		B/O	-11	1	LOCK NUT	STEEL	AN363-820	
		B/O	-13	2	WASHER	STEEL	AN960-816	
		B/O	-15	2	DOWEL PIN	STEEL	Ø1/4 X 1 (MCMaster-CARR #98381A542)	
		B/O	-17	3	#2 DRIVE SCREW	COATED STEEL	#.2 X 3/16 (MCMaster-CARR #91654A076)	
		B/O	-19	2	PLUMBER'S FLAT LINK CHAIN	STEEL	2/0 SIZE X 4-7/8 (MCMaster-CARR #3608T26)	
		B/O	-21	1	SPLIT RING	STEEL	Ø1 (MCMaster-CARR #90177A228)	
		B/O	-23	1	BALL LOCK PIN	S.S.	Ø3/16 X 3/4 (MCMaster-CARR #92384A013)	

DART AEROSPACE	
TITLE CLEVIS AND BELL	
DWG NO. RBT400224	
REV 3	
DRAWN BY: PERRITT	
APPROVED D Weir	
HEAT TREAT FINISH	
SPEC	
USED ON MODEL BELL 204	
SCALE 1:1	DATE 6/16/2009
SHEET 1 OF 4	

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REVISIONS			
REV	ECR	DESCRIPTION	DATE
			INITIAL
			APPROVED



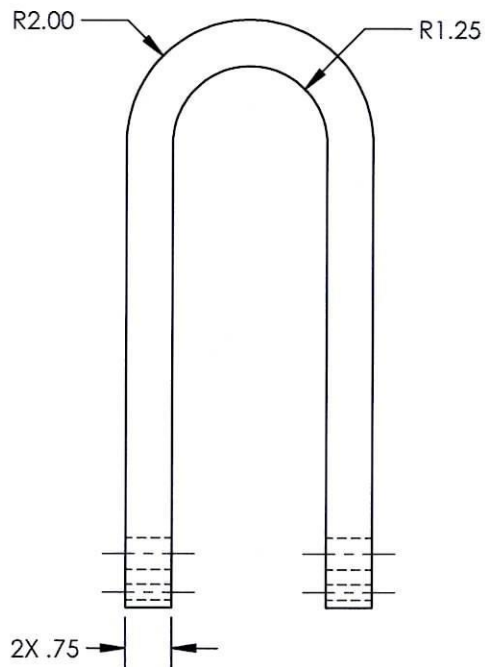
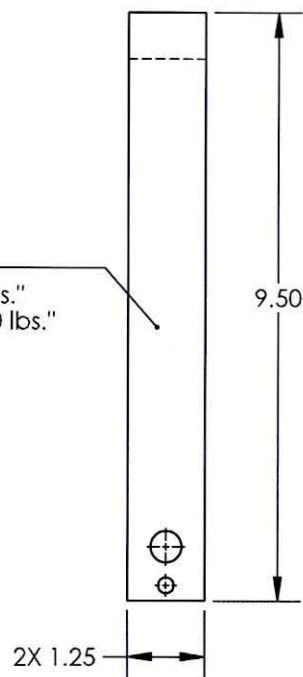
(-03)
CLEVIS

DART AEROSPACE	
TITLE CLEVIS & BELL	
DWG NO. RBT400224-03	REV 3
MAT'L 4140/4142	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D. Weil</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT RC 32-37
.XX ± .01 ANGLES ± 5°	TREAT CAD PLATE YELLOW
.X ± .1	FINISH QQ-P-416, TYPE II, CLASS II
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	BELL 204
SCALE 1:2	DATE 6/16/2009
SHEET 2 OF 4	

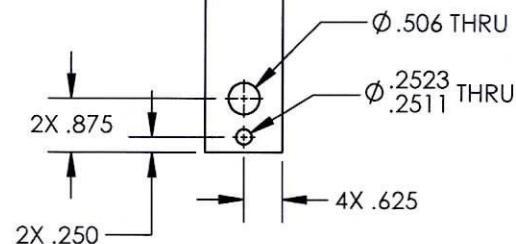
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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-05 CORRECTED PROOF LOAD TESTING FROM 40000 LBS. TO 25000 lbs. AND CAPACITY TO 10000 lbs. PER INFORMATION FROM STAN.	7/20/2010	WP	RW

ENGRAVE 3/16 HT
"CAPACITY 10000 lbs."
PROOF LOAD 25000 lbs."



ENGRAVE T/N, S/N,
MADE IN USA



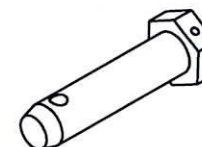
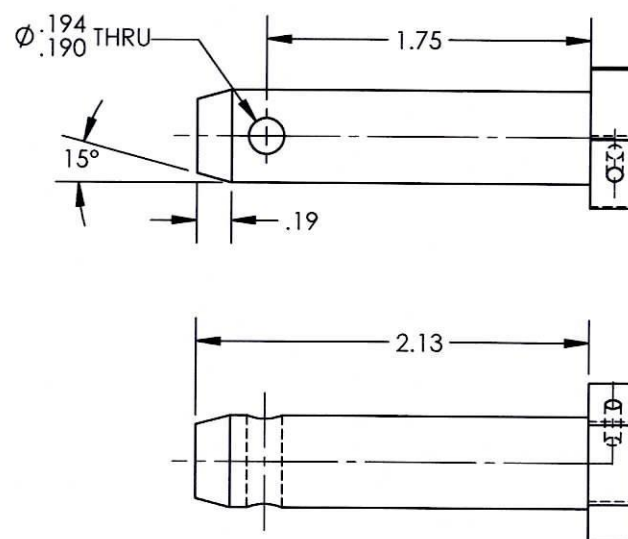
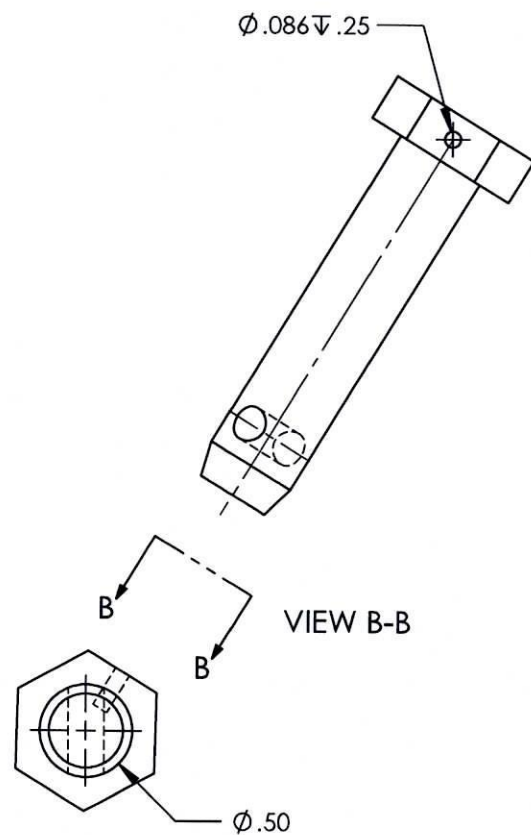
(-05)

BELL

DART AEROSPACE	
TITLE CLEVIS & BELL	
DWG NO. RBT400224-05	REV 3
MAT'L 4140/4142	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D. Weil</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT TREAT RC 32-37
.XX ± .01 ANGLES ± .5°	FINISH CAD PLATE YELLOW
.X ± .1	SPEC QQ-P-416, TYPE II, CLASS II
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	BELL 204
SCALE 1:3	DATE 6/16/2009 SHEET 3 OF 4

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		-07 CH'D FROM AN8-31A BACK TO NAS1308-38.	8/16/2010	WP	RW



(-07)

BOLT PIN

DART AEROSPACE	
TITLE CLEVIS & BELL	
DWG NO. RBT400224-07	REV 3
MAT'L STEEL	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT
.XX ± .01 ANGLES ± 5°	TREAT
.X ± .1	FINISH CAD PLATE YELLOW
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC QQ-P-416, TYPE II, CLASS II
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
	BELL 204
SCALE 1:1	DATE 6/16/2009 SHEET 4 OF 4



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO038711

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO038711
PO Date: 1/2/18
Due Date: 1/30/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

E-MAILED
JAN 04 2018

Items											
Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	RBT400224P			Clevis Assembly As per Dwg RBT400224 Rev.3	Firmed	1/30/18	2 pcs	0 pcs	2 pcs	\$1,760.00/pcs	\$3,520.00
										Grand Total:	\$3,520.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

[Handwritten signature]
CL
DOB



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity

Part Number

Part Name

P.O. Number

2 set

RBT400224P

Clevis Ass'y

38711

MATERIAL: supplied by METEC

We hereby certify that the above parts were made in conformance with applicable drawings.

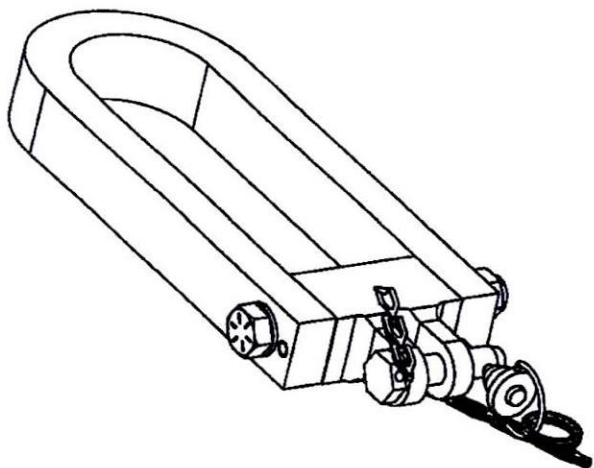
METEC Metal Technology Inc.

A handwritten signature in blue ink, appearing to read "Jan Norris", is written over the printed name.

Jan Norris

Vankleek Hill, March 21, 2018

FIRST ARTICLE WEIGHT TEST



INSPECTION & TESTING PROCEDURES FPR THE RBT40024 CLEVIS AND BELL.
THIS ASSEMBLY SHOULD BE INSPECTED BEFORE EACH USE
REPLACE ANY ITEMS THAT ARE DAMAGED OR SUSPECTED
TO HAVE BEEN DAMAGED BEFORE USE!

FIRST ARTICLE WEIGHT TEST

1. AFTER INSPECTION, PLACE LIFTING TOOL IN THE APPROPRIATE FIXTURE AND UE BALL LOCK PIN TO LOCK INTO FIXTURE.
2. APPLY 25,000 lbs FOR AT LEAST 5 MINUTES, CONTINUALLY CHECKING FOR CRACKS, DEFLECTION, OR DISTORTION.
3. REMOVE WEIGHT AND RE-INSPECT TOOL, CHECKING FOR STRESS CRACKS, BENDING, OR DISTORTIONS.

INSPECTOR

TESTER *ALAN PATRY*

S.N. *5053640*

DATE *2018/03/23*

DAS
38
9-89

 DART AEROSPACE 190 S. Danebo Ave., Eugene, OR. 97402 1-800-556-4166 e-mail: sales@dartaero.com dartaerospace.com			
TITLE CLEVIS AND BELL			
DWG NO. RBT400224	REV 3	CUSTOMER 1 OF 1	
SCALE 1:4	DATE 16/06/2009	SHEET 2 OF 2	